

# Work Order ID 70412

Tuesday, June 07, 2011 1:39:25 PM



Page 1

Item ID: D3414-3	Accept		Setup	Start	
Revision ID:					
Item Name: Lug				Stop	
Start Date: 6/7/2011	Start Qty: 40.00		Cust Item ID:		
Required Date: 6/21/2011	Req'd Qty: 40.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>CL</u>	Date: <u>11/06/07</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3414	Rev C

100		0.00							
Bandsaw	Memo	0.00		<u>11/06/08</u>		<u>40</u>			
Jeaspa Bandsaw	Cut blanks: 2.50" x 0.500" x 2.250" long								

110		0.00							
HAAS 1 Precision	Memo	0.00				<u>CL</u>	<u>11/06/09</u>	<u>40</u>	
HAAS CNC-vertical machine #1	Machine as per Folio FA569 and Dwg D3414 Identify as D3414-3 <input type="checkbox"/> Dwg Rev <input type="checkbox"/> Folio Rev <input type="checkbox"/>			<u>issue R10 14260</u>					

Dan's Precision Machine as per Dwg D3414 Rev C

120		0.00							
QC	QC2- Inspect parts off machine FAI/FAIB	0.00							
Quality Control	Memo	0.00							

rec'd + inspect for transit damage  
attached c/c to w/o

Rec'd 7/5 (38)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 70412**

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Item ID: D3414-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 6/7/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 6/21/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sulox

counted  
x38

140

Identify as per dwg &amp; Stock Location:

0.00



Packaging

Memo

0.00

Packaging

w/A  
030

11-7-7 x38

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/11

ME 11-07-07

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 70412



Parent Item: D3414-3



Parent Item Name: Lug

Start Date: 6/7/2011

Required Date: 6/21/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A 05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.500X2.500		Purchased	No			100	f	28.3750	0.1875	7.5			

304 BAR .500 x 2.50

Location

Loc Qty

Loc Code

MAT050

28.375

112764

16

116135

0.375

117685

12

7.65 AS 11/06/08

D3414-3P

2 11/7/5 (38)

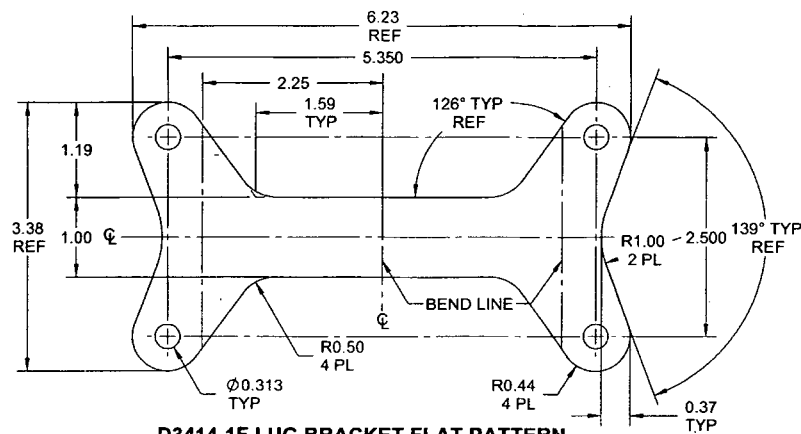
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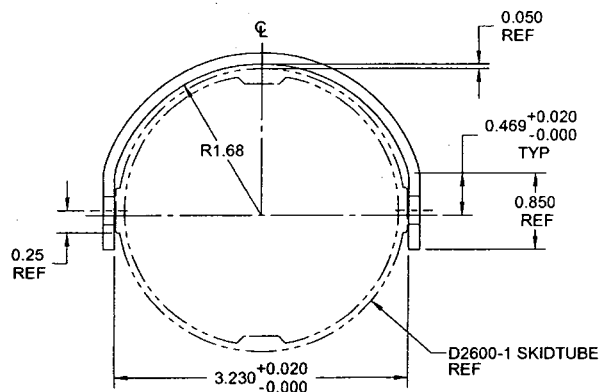
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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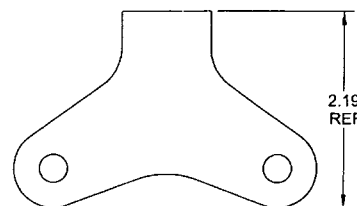
**NOTE:** Date & initial all entries



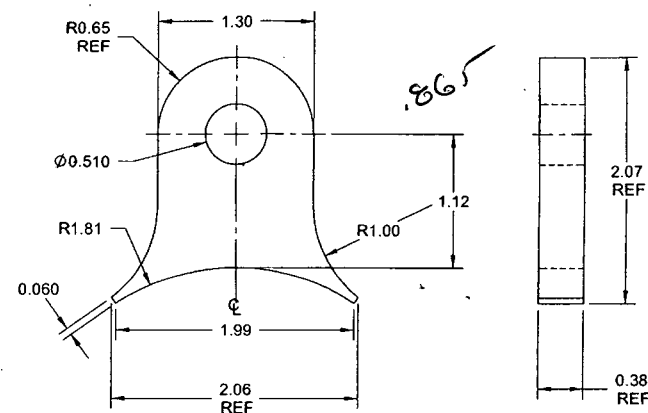
**D3414-1F LUG BRACKET FLAT PATTERN**



**D3414-1 LUG BRACKET**



SIDE VIEW FOR REF ONLY



**D3414-3 LUG**

NOTES:  
1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S

2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX  
-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A  
7) WEIGHT: N/A

C211106107  
W19: 70412

RELEASED

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	CP	DRAWING NO. <b>D3414</b>	REV. C
MFG. APPR.	CP	SHEET 3 OF 3	
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	<b>LUG ASSEMBLY</b>	NTS
DATE	09.06.17	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**DAN'S PRECISION TOOLS INC.**

2560 Devine Road, Vars, ON K0A3H0  
Tel: (613) 835-3097 Fax: (613) 835-3760  
support@dans-precision-tools.com

**RE: CERTIFICATE OF COMPLIANCE**

**To:** DART AEROSPACE LTD.  
1270 Aberdeen Street  
Hawkesbury ON K6A-1K7  
Tel: (613) 632-5200  
Fax: (613) 632-5246

- We Certify that the part listed below meets the intent of the Purchase Order, and all applicable drawings and specifications.

Date : 04-Jul-11  
Purchase Order : PO14260  
Packing Slip : 10537  
Part Number : D3414-3revC  
Quantity : 38

8/16/11/06

Per: \_\_\_\_\_

For Dan's Precision Tools Inc.

**DAN'S PRECISION TOOLS INC.**

Customer: DART AEROSPACE

P.O.: PO14260

W/O: \_\_\_\_\_

Part #: D3414-3 rev C

Lug Assembly, Lug

Qty: ~~10~~ 38

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